

Work Order ID 59760

Thursday, June 10, 2010 2:44:44 PM



Page 1

Item ID: D119-696-013

Accept



Setup Start



Revision ID:

Item Name: Dual Cargo Mirror Installation

Stop



Start Date: 6/10/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-6-10 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev U/R

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

Photocopy bluefile & type labels per PPP D119-696-013

CHG004

Schedule

for BG 10/6/10

110



Packaging

Packaging

Packaging Pick kit

0.00

0.00

Memo

=7m-f 10/06/11

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

Memo

Schedule

(+2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Packaging

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D119-696-013

Location: CPPP Rev: C

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

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Work Order ID: 59760



Parent Item: D119-696-013



Parent Item Name: Dual Cargo Mirror Installation

Start Date: 6/10/2010

Required Date: 6/18/2010

Comments: IPP Rev:A□08-02-19□New issue □DD verified by: LL

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No				Each	5,752.000	2	4		10-6-15 sf	

S ₂ Insert		Location	Loc Qty	Loc Code	
AN526-1032R9		PKG11	5000		
		114723	5000		
		ST282	305		
		110511	38		
		114407	267	X	
		ST381	447		
		114654	447		
			Each	118.0000	4 ~ 8

S ₂ Screw		Location	Loc Qty	Loc Code	
AN960JD10	NAS1149D0363J	Purchased	No		
		ST328	118		
		113928	1		
		114382	117		
			Each	0.0000	~4 ~ 8

S ₂ Washer		Location	Loc Qty	Loc Code	
D119-696-043		NAS1149D0363J	5	8X m-f w/06/11	
			Each	0.0000	1 ~ 2

S ₂ Dual Cargo Mirror Assy		Location	Loc Qty	Loc Code	
		N1114292	8X m-f w/06/11		
			Each	0.0000	1 ~ 2

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Parent Item: D119-696-013



Parent Item Name: Dual Cargo Mirror Installation

Start Date: 6/10/2010

Required Date: 6/18/2010

Comments: IPP Rev:A 08-02-19 New issue DD verified by: LL

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2053 		Manufactured	No				Each	38.0000	1	2			

SPL Mounting Bracket

Location	Loc Qty	Loc Code
ST005	38	
47595	2	
58395 ✓	36	

D2067 		Manufactured	No				Each	12.0000	1	2			
-----------	--	--------------	----	--	--	--	------	---------	---	---	--	--	--

2X m-f 10/06/11

D2071 		Manufactured	No				Each	9.0000	1	2			
-----------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

2X m-f 10/06/11

D3083-1 		Manufactured	No				Each	0.0000	1	2			
-------------	--	--------------	----	--	--	--	------	--------	---	---	--	--	--

2X m-f 10/06/11
B51759 10-6-159

W/O:		WORK ORDER CHANGES					
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Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21919-DG5		Purchased		No			Each	30.0000	2✓	4			



6-12 Clamp

Location

ST306

114348 ✓

Loc Qty

20

20

ST319

114761

10

10

Purchased

Location

ST291

111650 ✓

Loc Code

455

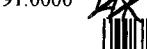
420

35

18057

Each

91.0000



4X m-f 10/06/11

MS27039-1-09



6-12 Screw

No

Location

ST291

111650 ✓

Loc Qty

455

420

35

18057

Each

91.0000



8X m-f 10/06/11

MS35489-9



5-12 Grommet

Purchased

No

Location

ST296

107376 ✓

Loc Code

91

11

109371

80



2
8X m-f 10/06/11

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25.2 CARGO MIRROR REMOVAL

1. Loosen MS21042-3 nut and remove D2071 control cable from D2067 connector.
2. Remove (4) MS27039-1-09 screws and remove D3072-1/-2 brackets. Re-install MS27039-1-08 screws.
3. Remove (2) AN526-1032R9 screws and (2) MS21919DG5 clamps.
4. Remove (2) AN526-1032R9 screws, the D2053 bracket and the D2071 cable assembly. Re-install AN526-1032R9 screws to plug inserts.
5. Seal MS35489-9 grommet hole with PRC / RTV / Proseal 890 / Sikaflex-241 / Sikaflex-291 / MIL-C-8802 Class B2 sealant.

25.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-696-011 Cargo Mirror Installation	2.2 lb 1.00 kg	7.0 in 0.28 m	15.4 in-lb 0.28 m-kg	22.0 in 0.87 m	48.4 in-lb 0.87 m-kg
D119-696-013 Cargo Mirror Installation	3.0 lb 1.36 kg	1.0 in 0.04 m	3.0 in-lb 0.05 m-kg	22.0 in 0.87 m	66.0 in-lb 1.18 m-kg

25.4 PARTS LIST

Qty -011	Qty -013	Qty -041	Qty -043	Part Number	Description
X				D119-696-011	SINGLE CARGO MIRROR INSTALLATION
	X			D119-696-013	DUAL CARGO MIRROR INSTALLATION
1		X		D119-696-041	SINGLE CARGO MIRROR ASSEMBLY
		1	X	D119-696-043//	DUAL CARGO MIRROR ASSEMBLY
		1	2	D2011-101	MIRROR ASSEMBLY
1	1			D2053	BRACKET
		2	2	D2054	BUSHING
		2	2	D2055	CLAMP
		1	1	D2056	BELL CRANK
		1		D2057	PLUG
1	1			D2067	CONNECTOR
1	1			D2071	CABLE ASSEMBLY
		1	2	*D3014-1	LOCKNUT
		1	1	D3072-1	BRACKET
		1	1	D3072-2	BRACKET
		1		D3074-1	ARM
			1	D3074-3	ARM
1	1			D3083-1	PLACARD
4	4			AN526-1032R9	SCREW
4	4	6	6	AN960JD10	WASHER
		1	2	*AN960JD416L	WASHER
		3	3	MS21042L3	NUT (or MS21042-3)
2	2			MS21919DG5	CLAMP
4	4			MS27039-1-09	SCREW
		3	3	MS27039-1-18	SCREW
1	1			MS35489-9	GROMMET
2	2			AKS7-1032-130	INSERT (or ALS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or AEIS-032-130)

*INCLUDED AS PART OF D2011-101 MIRROR ASSEMBLY

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25-00-00

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